

Date: Monday, 28/04/2008 10:10:32 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services		<b>Drawing Name</b>	: DOOR ASSEMBLY		
<b>Job Number</b>	: 38834					
<b>Estimate Number</b>	: 10711					
<b>P.O. Number</b>	:			<b>Part Number</b>	: D32131	
<b>This Issue</b>	: 28/04/2008		<b>S.O. No.</b>	: D3213 REV A		
<b>Prsht Rev.</b>	: NC			<b>Project Number</b>	: N/A	
<b>First Issue</b>	: / /		<b>Type</b>	: SMALL /MED FAB		
<b>Previous Run</b>	: 33119			<b>Drawing Revision</b>	: A	
<b>Written By</b>	:			<b>Material</b>	:	
<b>Checked &amp; Approved By</b>	:			<b>Due Date</b>	: 05/05/2008	
<b>Comment</b>	: Est Rev:A New Issue 05-11-17 JLM			<b>Qty:</b>	10	
	Est Rev:B Now on Waterjet 07-02-13 JLM			<b>Um:</b>	Each	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet  6.
		Comment: Qty.: 0.4950 sf(s)/Unit Total : 4.9497 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063)Identify as D3213-1 Batch: 105675  8-4-28
2.0	WATER JET	FLOW WATER JET  A A
		Comment: FLOW WATER JET
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  8-4-28
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK  08/04/28
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr  8-4-28
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1  
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1  ml 08/04/29 X12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 28/04/2008 10:10:33 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 38834

Part Number: D32131

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 08/04/25  
(12)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ML 08/04/12

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/30  
(12)

Job Completion



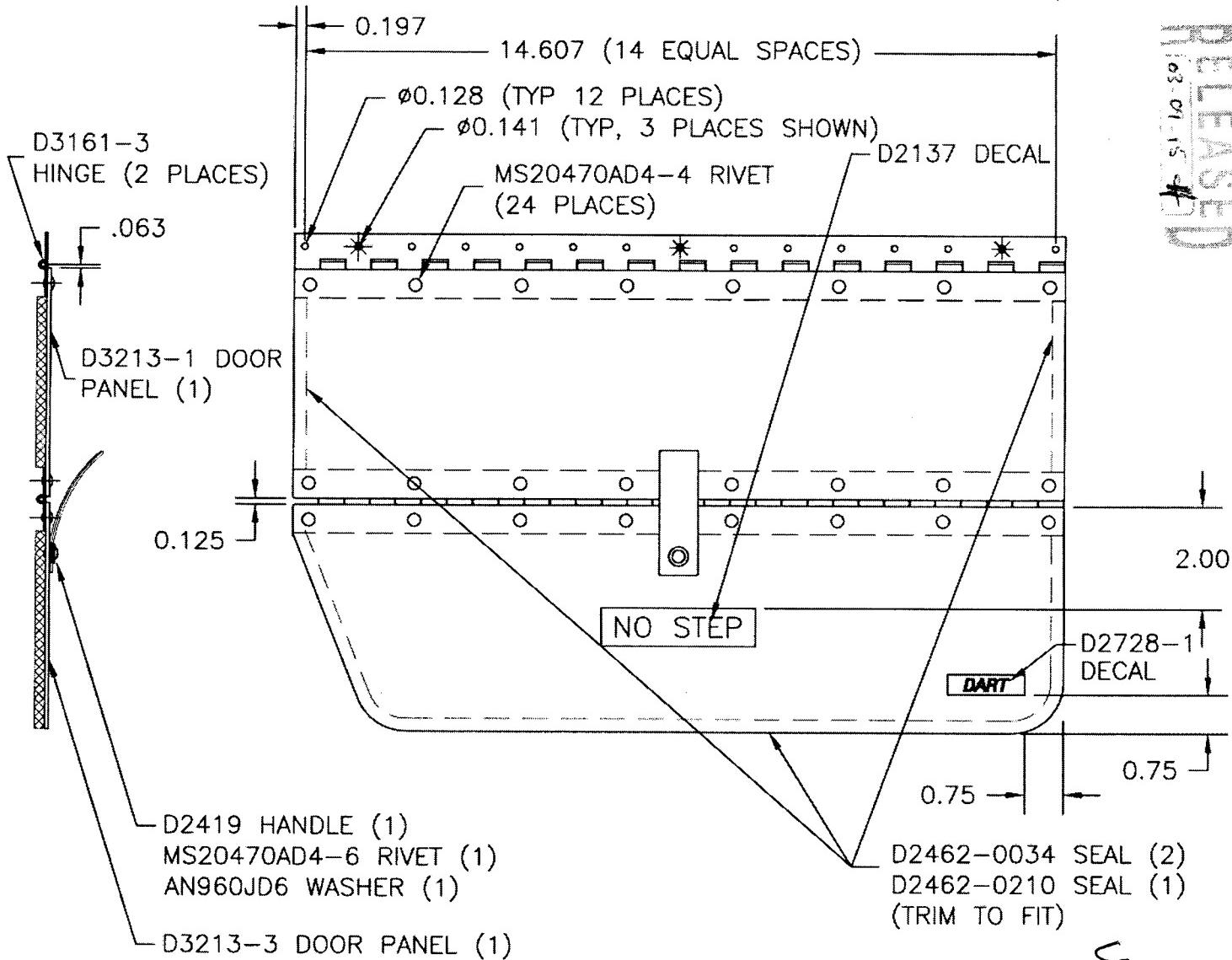
MF 08-04-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3

INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**DART**  
103-01-15 #

© COPY  
DRAFT

DESIGN	DRAWN BY	DART AEROSPACE LTD
11	JP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
#	#	D3213
DATE		REV. A
03.09.03		1 OF 2
A	03.09.03	SCALE
		1:3
		TITLE
		DOOR ASSEMBLY
		NEW ISSUE

W  
38834

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

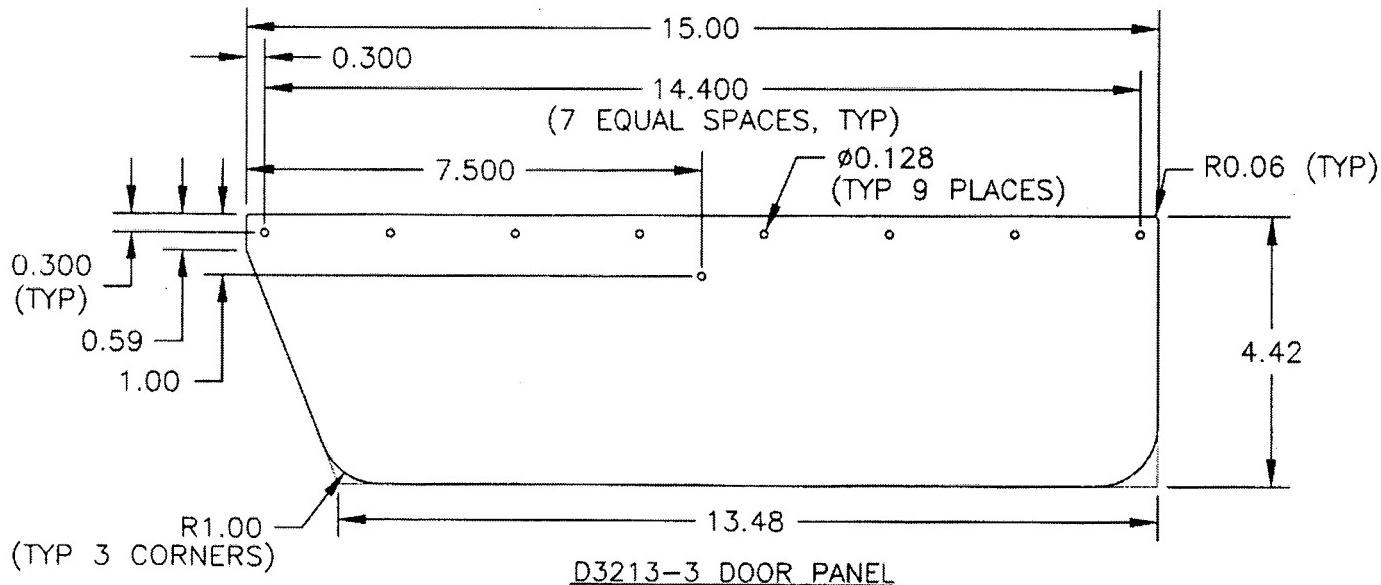
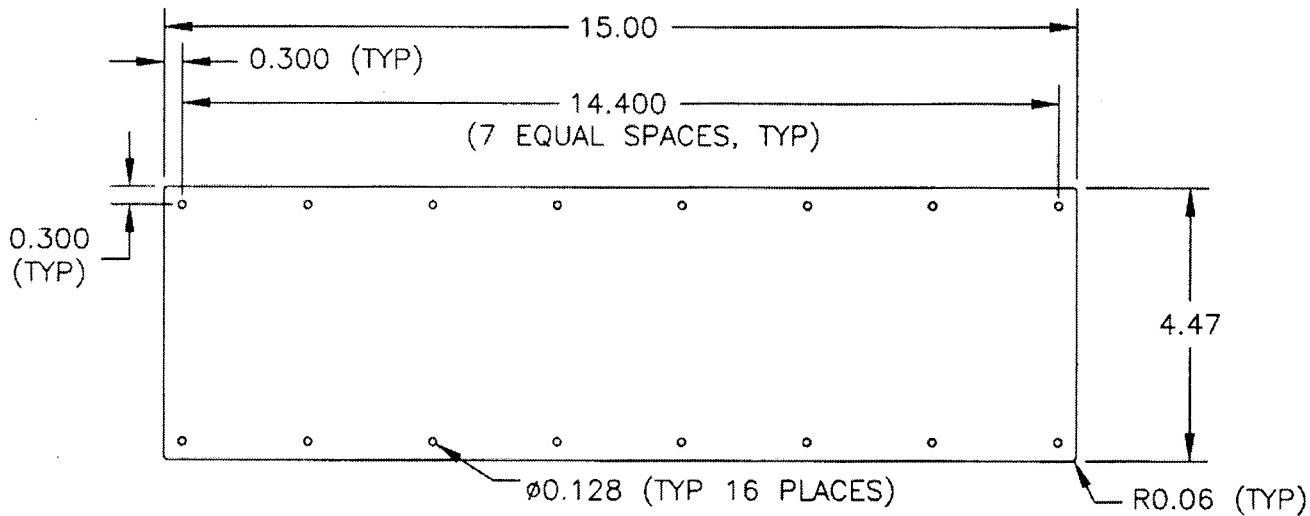
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3213
DATE		REV. A 2 OF 2 SCALE 1:3
03.09.03		TITLE DOOR ASSEMBLY

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
03.09.03

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38834
Description: DOOR ASSEMBLY	Part Number:	D3213-1
Inspection Dwg: D3213-1	Rev: A	Page 1 of 1

# **FIRST ARTICLE INSPECTION CHECKLIST**

**X** First Article      **Prototype**

Measured by:	HB	Audited by:	C	Prototype Approval:	N
Date:	8-4-08	Date:	08/04/08,	Date:	08/04/08

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	